

7346T15M

High Solids Polyurethane Topcoat

Technical Data Sheet

Product Group

Polyurethane topcoat

Characteristics



Product
Information

- This high solids, two-component coating is lead and hexavalent chromate free. This CARC coating is resistant to chemical agents for use on military combat equipment.
- This product is subject to International Traffic in Arms Regulations (ITAR).

Components



Curing Solution

Curing Solution 0320T06M

Specifications



Qualified
Product List

US Military

MIL-C-46168, TY IV

For most recent up-date or missing specifications please check the qualified product list (QPL) on www.akzonobel.com/aerospace

Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process
- Prepare surface per MIL-C-46168 and MIL-C-53072B

Instruction for Use



Mixing Ratio
(volume)

4 parts
1 part

Base 7346T15M
Curing Solution 0320T06M

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.

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Induction Time

30 minutes



Initial Spraying
Viscosity
(25°C/77°F)

11-27 seconds EZ Zahn-Cup #3



Note

Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.



Pot life
(25°C/77°F)

4 hours.



Dry Film
Thickness
(DFT)

46 – 51 micron (µm)
1.8 – 2.0 mils

Application Recommendations



Conditions

Temperature: 15 – 35°C
59 – 95°F
Relative Humidity: 35 – 75%



Note

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

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Equipment

Air 1.2-1.4 mm nozzle orifice
Atomizing air 45-65 psi, fluid 10-20 psi
HVLP 1.2-1.4 mm nozzle orifice
Input air <45 psi, fluid 5-15 psi



Number of
Coats

Spray to film two coats no flash necessary



Cleaning of
Equipment

MEK

Physical Properties



Drying Times
(25 +/- 2°C / 77
+/- 2°F, 55 +/-
5% RH)

Set to touch 30 minutes
Dry hard 3 hours
Dry through 4 hours



Theoretical
Coverage

20 m² per liter ready to apply at 25.4 µm dry film thickness
820 ft² per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

51.8 g/m²/ 25.4 micron
0.01 lbs/ft²/1 mil



Volatile Organic
Compounds

Max 420 g/l
Max 3.50 lb/gal



Gloss (60°)

0.5 GU
1 GU

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Color

Aircraft green 595B-34031



Flash-point

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0320T06M

-4°C / 25°F
35°C / 95°F



Storage

Store the product dry and at a temperature between 5 and 38°C / 40 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life
5 - 38°C
(40 - 100°F)

18 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDS's are available on request.

Issue date: October 2020 (supersedes February 2015) - FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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